

ABSTRACT

A safety valve element for battery use which ruptures at a stable pressure range so as to release the inner pressure of the battery is disclosed. The safety valve element for battery use comprises a metal substrate which is provided with a perforated opening and a metal foil laminated on the metal substrate so as to close the perforated opening. A battery which is provided with such a safety valve is also disclosed. A battery case provided with such a safety valve is also disclosed. The battery and the battery case lid is produced by forming the perforated opening in the metal substrate, pressure welding the metal foil to the metal substrate and molding the clad material into a form of the battery case lid.